

# Work Order ID 105348

\*105348\*

Page 1

August-01-13 11:24:08 AM

Item ID: D2523

Revision ID:

Item Name: Mounting Bracket

Start Date: 8/01/13 Start Qty: 6.00

Required Date: 8/01/13 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan: MLS

Date: 13-08-06 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2523

Rev A2

100

\*100\*

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blank: 21.75" x 12.00"

NOTE: 1 BLANK MAKES 2 PARTS

0.00

0.00

DR/MS 13/08/21

3

6

110

\*110\*

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine as per folio D2523

0.00

0.00

DR/MS 13/08/23  
DR 13/08/24

13/08/23  
13/08/24

6

6

120

\*120\*

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

DR/MS 13/08/23  
DR 13/08/24

13/08/23  
13/08/24

6

6

Run

Start

\*NR1\*

Stop

\*NR2\*

Setup

Start

\*NS1\*

Stop

\*NS2\*

Cust Item ID:

Customer:

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: <u>105348</u> Part No. <u>D2523</u> NCR No. <u>13-3258</u>	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b> <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input checked="" type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input checked="" type="checkbox"/>	13/8/23	110	Z	<del>DEEP</del> TOOL MARKS IN (2) PARTS.  RE all st + Re Polio not clean	UP 13/8/23	SCRAP + Destroy  26.94	UP 13/8/23	Reg updated 13.08.23 13/08/23	5 13/08/23
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

## FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input checked="" type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

# Work Order ID 105348

\*105348\*

Page 2

August-01-13 11:24:08 AM

Item ID: D2523

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Mounting Bracket

Start Date: 8/01/13 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 8/01/13 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC8- Inspect parts - second check

0.00

\*130\*

QC

Memo

0.00

Quality Control

140

0.00

\*140\*

Small Fab

Small Fab

Memo

0.00

Small Fab

DeburDrill holes as per dwg D2523 using DT8560

150

QC5- Inspect part completeness to step on W/O

0.00

\*150\*

QC

Memo

0.00

Quality Control

## WORK ORDER NON-CONFORMANCE / UPDATE

Date \_\_\_\_\_

7/3/12/05

QA Closed

Date \_\_\_\_\_

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	13/8/26	110	2	0.750 DIM 15 0.765 ON QTY (2), WE TO STOCK MAT'L THICKNESS. PL <u>MATERIAL</u>	CP 13/8/26	Acceptable.  J2230-1 CLAMP WILL STILL INSTALL	CP 13/8/26	PP 13 . 9	DAS 16 9-89 13/11/13
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier	12.11.07	110	1	Ø0.191" HOLES DRILLED ON WRANK Sides, from DIM 15 0.765	1 12.11.07	SCRAP NO REPAIR.	FF 13-11-07	4 SWP 13 11 07	

**FAULT CATEGORY**

Landing Gear		General			
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced	
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure	
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Weld	
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled	
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved		
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong		
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Other	
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset			
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration			
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence			
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions			

# Work Order ID 105348

\*105348\*

Page 3

August-01-13 11:24:08 AM

Item ID: D2523 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Mounting Bracket  
 Start Date: 8/01/13 Start Qty: 6.00 \*6\* Cust Item ID:  
 Required Date: 8/01/13 Req'd Qty: 6.00 \*6\* Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				5	785	13-11-9	
170 *170* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M 126824. Memo START TIME: 2:15 OVEN TEMPERATURE: FINISH TIME: 2:45	0.00  0.00				5	φ	13-11-11	DAS 34 9-89
180 *180* QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				5			

DAS  
27  
9-89

13/11/15

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube <input type="checkbox"/></td> <td style="width:25%;">Crosstube <input type="checkbox"/></td> <td style="width:25%;">Water Jet <input type="checkbox"/></td> <td style="width:25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
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**\*105348\***

August-01-13 11:24:08 AM

**\*N900040100\***

Stop \*NS2\*

**Start Date:** 8/01/13      **Start Qty:** 6.00      **\*6\***

**Cust Item ID:**

**Required Date:** 8/01/13      **Req'd Qty:** 6.00      **\*6\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

### Operation Description

### Set Up/ Run Hours

**Tool ID****Tool #****Plan  
Code**

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

190

Identify as per dwg & Stock Location: 57/66 0.00

0.00

**\*190\***

## Packaging

## Memo

0.00

### Packaging

200

QC21- Final Inspection - Work Order Release

0.00

**\*200\***

QC

## Memo

0.00

### Quality Control

**DAS**  
**32**  
**9-89**

13/11/18 (5)

13/11/20

pl B 11-1

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

**FAULT CATEGORY**

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other



# Picklist Print

August-04-13 11:24:08 AM

Page 1

Work Order ID: 105348

Parent Item: D2523

Parent Item Name: Mounting Bracket

Start Date: 8/01/13

Required Date: 8/01/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP C01.04.16Re format, added DT8560EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X12.000		Purchased	No			100	f	48.4600	1.8125	11.447368			
6061-T6 Bar 1.00 x 12.00													

Location	Loc Qty	Loc Code
MAT006	48.46	
16406	6.5	
124443	5.96	
M126075	24	
M126351	12	

5.4375

DR/B 13/08/21

Material was not identified

Batch # from Supplier is 201221SG4.

~~Material~~ Approx. 4# Left.

Used 8 1.903

MH 13/08/23

Use 13-3204

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
<b>Root Cause</b>	<b>Date</b>	<b>Step</b>	<b>Qty</b>	<b>Description of work order update or Non-conformance</b>	<b>Initial Chief Eng</b>	<b>Action Description</b>	<b>Sign &amp; Date</b>	<b>Verification</b>	<b>QC Inspector</b>		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY			
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	105348
<b>Description: Mounting Bracket</b>		<b>Part Number:</b>	D2523
<b>Inspection Dwg: D2523      Rev: A2</b>		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.005/-0.000	.2585	✓		MH-04	Caliper
1.076	+/-0.010	1.076	✓			
1.985	+/-0.010	1.985	✓			
Ø0.257	+0.005/-0.001	.2585	✓			
9.372	+/-0.010	9.372	✓		cnc-02	
1.035	+/-0.010	1.035	✓			
Ø0.191	+0.005/-0.000	.193	✓			
7.546	+/-0.010	7.546	✓		Cnc-02	
2.776	+/-0.010	2.776	✓			
2.776	+/-0.010	2.777	✓			
0.875	+/-0.010	.8755	✓			
R0.125	+/-0.010	.125	✓		rad gauge	-
1.00	+/-0.030	1.005	✓		MH-04	Caliper
R0.125	+/-0.010	.125	✓		rad gauge	-
0.750	+/-0.010	.			MH-04	Caliper
0.250	+/-0.010	.253	✓			
R0.250	+/-0.010	.250	✓		rad gauge	-
0.125	+/-0.010	.120	✓		MH-01	Micro
R0.125	+/-0.010	.125	✓		rad gauge	-
R0.063	+/-0.010	.063	✓			-

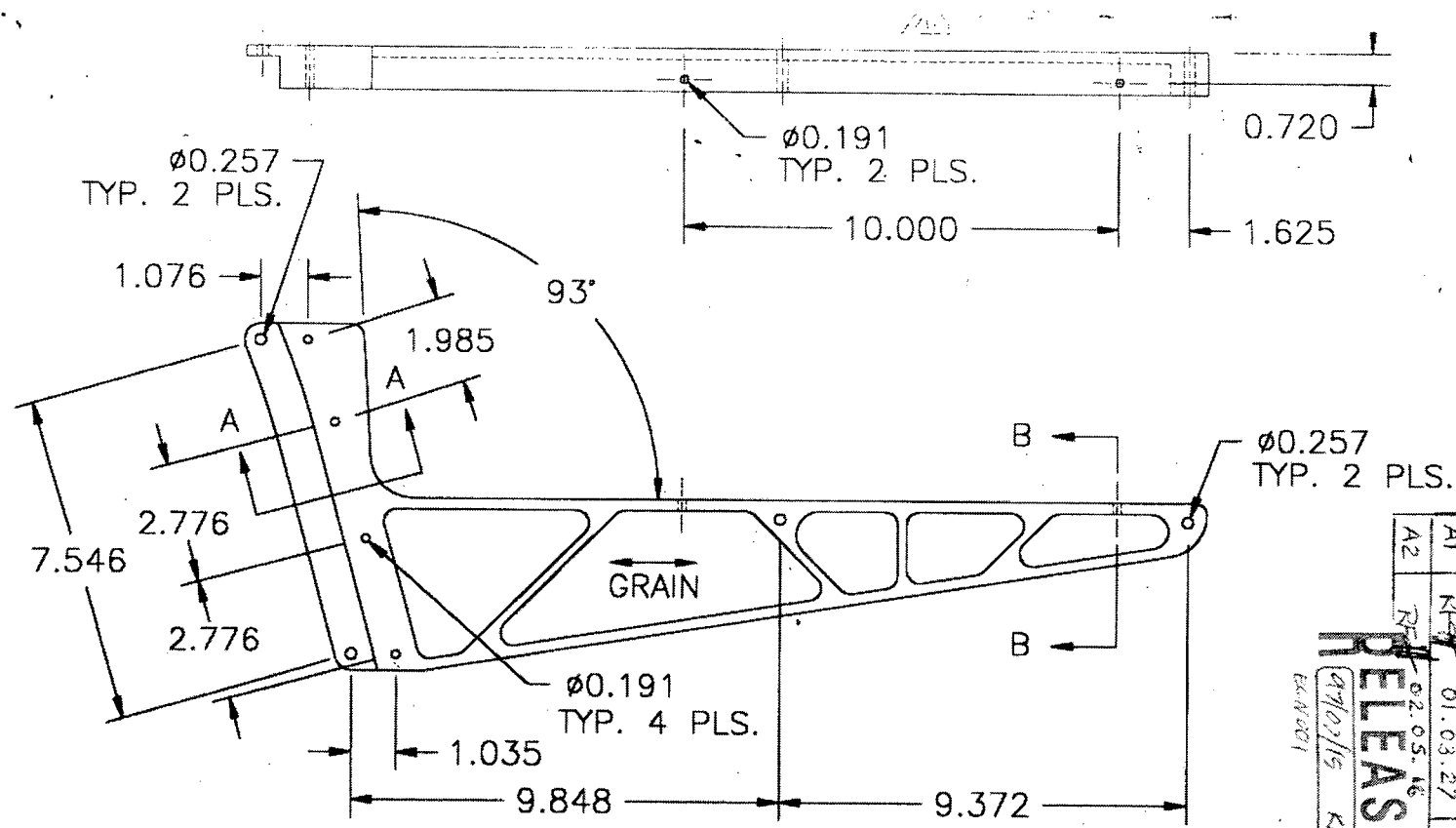
<b>Measured by:</b> MH	<b>Audited by:</b> RP	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 13/08/23	<b>Date:</b> 13-9-4	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	

-0905  
-129

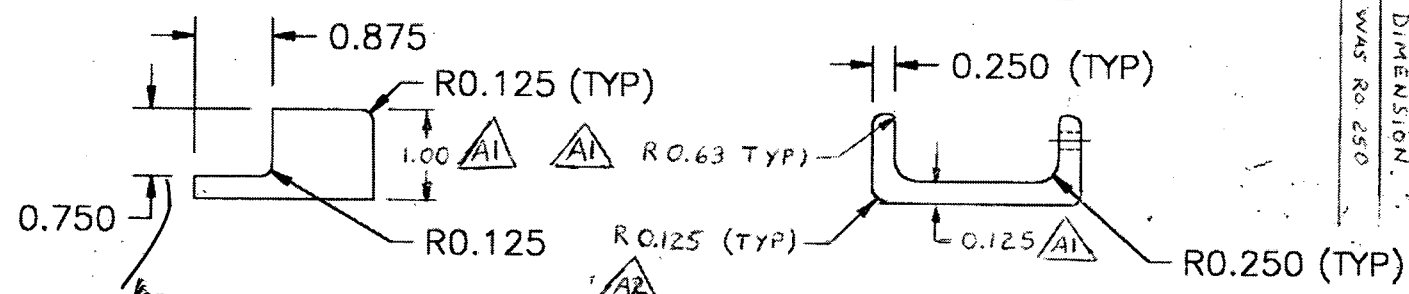
**DART**

105348  
MLJ  
13-08-06



SECTION A-A  
SCALE 1:2

SECTION B-B  
SCALE 1:2



MATERIAL: 6061-T6 QQ-A-200/8 1.00 THICK  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE PER DART QSI 005 4.3

RELEASED  
9/10/15 KE  
E6/N001

DESIGN	DRAWN BY	DART AEROSPACE LTD
B2	KE	VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	APPROVED	DRAWING NO.
[Signature]	[Signature]	D2523
DATE	TITLE	REV. A
95.12.20	MOUNTING BRACKET	SHEET 1 OF 1
95.12.20	NEW ISSUE	SCALE 1:4
A1	01.03.27	ADDED DIMENSION.
A2	02.05.16	R0.125 WAS R0.250

Copyright 1995 by DART AEROSPACE LTD



# Receiving Report

124443  
18936

Batch No:

Date P/O:

Date:

Supplier:

Packing Slip:

Invoice:

Receipt:

Yes

Yes

Cash

No

No

Cr

Release Note Attached:

Yes

No

Waybill Attached:

Yes

No

Shipment Complete:

Yes

No

QC Inspection

N/A

N/A

N/A

N/A

N/A

N/A

N/A

N/A

N/A

N/A

N/A

N/A

N/A

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N/A

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Production/Admin:

Date

Received/Costing

Initial

13-01-30

SP

Location

SP

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

## Purchase Order Receipt Listing

Wednesday, January 30, 2013 7:55:07 AM

All Vendors PO ID PO18936 Receipt Dates from  
All Item ID/GL/WOs All Rec. Employees All C  
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	P S
VendorID\Vendor Name PO18936	1	VC-COP001	Thyssekn M6061T6B0.250X02.1 500	
CAD	No		6061-T6 Bar 0.25 x 2.50 124443	
	2		M6061T6B0.250X04. 000	
	No		6061-T6 Bar .250 x 4.00 124443	
	3		M6061T6B0.375X01. 000	
	No		6061T6 BAR .375 x 1.00 124443	
	4		M6061T6B0.375X03 000	
	No		6061T6 BAR .375 X 3.00 124443	
	5		M6061T6B0.500X02 500	
	No		6061-T6 Bar .500 x 2.50 124443	
	6		M6061T6B0.750X0 750	
	No		6061-T6 Bar .750 x .750 124443	

## B I L L O F L A D I N G

No: PEC 805103

Ship From: THYSSENKRUPP MATERIALS NA  
2821 LANGSTAFF ROAD  
CONCORD, ONTARIO L4K 5C6  
Tel: 905 669 9444 Fax: 905-738-9033

Ship Date 28Jan13 at 11:14 From PFW.  
Probill  
Via VIM TRANSFER  
FOB CONCORD  
Frt PREPAID  
Route 0-0 Manifest  
Vhcle Trailer  
Slp STAN IVERS (905-532-1350)  
Sold To: (20115)  
DART AEROSPACE

Ship To: (1)  
DART AEROSPACE

## B I L L O F L A D I N G

✓ 6) Our Order PEC-530434- 6 Your PO # 18936  
ALUMINUM SQUARE BAR 6061-T6511  
.750" X 144.0000"

Heat Number  
12090031A

Tag No  
144964

Quantity  
12 FT

PCS  
1

Wt LBS  
8

✓ 7) Our Order PEC-530434- 7 Your PO # 18936  
ALUMINUM FLAT BAR 6061-T6511  
.750" x 4.00" X 144.0000"

Heat Number  
201221010

Tag No  
144965

Quantity  
12 FT

PCS  
1

Wt LBS  
43

✓ 8) Our Order PEC-530434- 8 Your PO # 18936  
ALUMINUM FLAT BAR 6061-T6511  
.125" x .750" X 240.0000"

Heat Number  
12110331A

Tag No  
144966

Quantity  
100 FT

PCS  
5

Wt LBS  
11

✓ 9) Our Order PEC-530434- 9 Your PO # 18936  
ALUMINUM FLAT BAR 6061-T6511  
1.00" x 2.00" X 144.0000"

Heat Number  
201221186

Tag No  
144967

Quantity  
36 FT

PCS  
3

Wt LBS  
86

✓ 10) Our Order PEC-530434- 10 Your PO # 18936  
ALUMINUM FLAT BAR 6061-T6511  
1.00" x 2.50" X 144.0000"

Heat Number  
2BS870

Tag No  
144968

Quantity  
12 FT

PCS  
1

Wt LBS  
35

✓ 11) Our Order PEC-530434- 11 Your PO # 18936  
ALUMINUM FLT BAR ECONOPLT 6061-T6511  
1.00" X 12.00" X 144.5000"

Heat Number

Tag No

Quantity PCS

Wt LBS

Page: 2 ....Continued

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ÊTRE  
RAPPORTÉES IMMÉDIATEMENT.  
ERRORS OR SHORTAGE MUST BE REPORTED IMMEDIATELY  
RETOUR DE MARCHANDISES AVEC NOTRE NUMÉRO D'APPROBATION SEULEMENT.  
MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER.

REÇU EN BONNE CONDITIONS / RECEIVED IN GOOD CONDITION

DATE

501301-30

## B I L L O F L A D I N G

No: PEC 805103

Ship From:  
THYSSENKRUPP MATERIALS NA  
2821 LANGSTAFF ROAD  
CONCORD, ONTARIO L4K 5C6  
Tel: 905 669 9444 Fax: 905-738-9033

Ship Date 28Jan13 at 11:14 From PFW  
Probill  
Via VIM TRANSFER  
FOB CONCORD  
Frt PREPAID  
Route 0- 0 Manifest  
Vhcle Trailer  
Slp STAN IVERS (905-532-1350)  
Sold To: (20115)  
DART AEROSPACE

Ship To: (1)  
DART AEROSPACE

===== B I L L O F L A D I N G =====  
201221564 145079 12 ' .5000 " 1 170

12) Our Order PEC-530434- 12 Your PO # 18936

ALUMINUM PLATE 6061-T651

1.00" THICK X 15.0000" X 144.5000"

Heat Number  
09/10/026C0

Tag No  
144593

Quantity PCS  
15.05 SFT 1

Wt LBS  
219

13) Our Order PEC-530434- 13 Your PO # 18936

ALUMINUM SQUARE BAR 6061-T6511

1.250" X 144.0000"

Heat Number  
2BR922

Tag No  
144969

Quantity PCS  
48 FT 4

Wt LBS  
88

14) Our Order PEC-530434- 14 Your PO # 18936

ALUMINUM FLAT BAR 6061-T6511

1.250" x 1.50" X 144.0000"

Heat Number  
Z00261029

Tag No  
144970

Quantity PCS  
36 FT 3

Wt LBS  
80

15) Our Order PEC-530434- 15 Your PO # 18936

ALUMINUM SQUARE BAR 6061-T6511

2.00" X 144.0000"

Heat Number  
201219894

Tag No  
144971

Quantity PCS  
36 FT 3

Wt LBS  
172

16) Our Order PEC-530434- 16 Your PO # 18936

ALUMINUM FLAT BAR 6061-T6511

2.00" X 8.00" X 144.0000"

Heat Number  
201201586

Tag No  
144972

Quantity PCS  
12 FT 1

Wt LBS  
224

17) Our Order PEC-530434- 17 Your PO # 18936

ALUMINUM FLAT BAR 6061-T6511

1.50" x 2.50" X 144.0000"

Page: 3 ....Continued

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ÊTRE  
RAPPORTÉES IMMÉDIATEMENT  
ERRORS OR SHORTAGE MUST BE REPORTED IMMEDIATELY  
RETOUR DE MARCHANDISES AVEC NOTRE NUMÉRO D'APPROBATION SEULEMENT.  
MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER.

REÇU EN BONNE CONDITIONS / RECEIVED IN GOOD CONDITION

DATE

SEP 13-01-30



# THYSSENKRUPP MATERIALS NA

DART AEROSPACE

ALUMINUM FLT BAR ECONOPLT 6061-T6511  
1.00" X 12.00" X 144.5000"  
PART NO.

PO/Rel 18936

We certify that this is a true copy of the report  
furnished by the producer of the metal, or data  
resulting from tests made in approved labs.

Signed by: \_\_\_\_\_

## Certificate of Mill Test Results

BL PEC-805103-011

28Jan13

Pg 1/1



SERVICE CENTER METALS  
5850 Quality Way  
Prince George, VA 23875

### CERTIFIED INSPECTION REPORT AND TEST RESULTS FOR EXTRUDED PRODUCTS

SELL TO

ThyssenKrupp Materials NA

SHIP TO

ThyssenKrupp Materials NA PEC

Quantity Certified 2,032 lbs 12 pcs

MANIFEST NUMBER

176547

CUSTOMER PO

PEC-244313

CUSTOMER PART NUMBER

PL0741

DIE NUMBER

PL0741

ALLOY / TEMPER

6061-T6511E

DESCRIPTION

PL 1.000 x 12.000

DATE OF SHIPMENT

12/13/2012

SALESPERSON

David Schroeder

OUR ORDER NUMBER

164614

ITEM

3

CERTIFICATION

ASTM-B221-12 StencilContinuous

SPECIFICATION

AMS-QQA-200/8

We hereby certify that the material covered by this report has been inspected in accordance with the most recent certification revision, and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description, and that samples representative of the material met the composition limits and had the mechanical properties shown. SCM extrusions are manufactured in the USA.

#### Mechanical Properties

Tests	Lot No.	Test Date	Ultimate Tensile Strength (KSI)	Yield Strength (KSI)	Percent Elongation
1	201221564	12/10/12	50.1	46.7	14.7

DAS 13/01/30 14 9-8

#### Chemical Composition for Aluminum Alloy 6061

Cast Number	Alloy	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	AL	Others Each	Total	Melt Source:
1112080	6061	0.76	0.37	0.31	0.11	0.90	0.11	0.05	0.02	97.37	0.05	0.15	United States of America
1112157	6061	0.75	0.34	0.32	0.10	0.87	0.10	0.07	0.02	97.43	0.05	0.15	United States of America

*Calvin J. Wiggins*

Calvin J. Wiggins, Director of Quality & Technical Services

Print Date: 12/13/2012

Rev. 9/23/11 - UMS